



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-615-041
Job Sheet 178533



005025

Ship Aug 20

Part No: D350-615-041

Job Qty: 25 ea

Part Name: Ground Handling Wheel Modification, Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/1/18

Job Tracking No:

Due Date: 8/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: IIN REV B IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L revise bom DD 10.03.18 verified by:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier			
90	Start up Operation	25 Ea	8/20/18	8/20/18	0.00	0.00	Start Up Small Fab-4			DAS 8 58 18/18
110	Small Fab	25 pcs	8/20/18	8/20/18	0.00	2.30	Small Fab-4			DAS 38 89 9-89
120	QC	25 pcs	8/20/18	8/20/18	0.00	0.00	QC5			SRB 9-89
130	QC	25 pcs	8/20/18	8/20/18	0.00	0.00	QC4			SRB 9-89
140	Packaging	25 pcs	8/20/18	8/20/18	0.00	0.00	Packaging3-1			SRB 9-89
145	DC	25 pcs	8/20/18	8/20/18	0.00	0.00	DC			SRB 9-89
150	QC21-FG	25 Ea	8/20/18	8/20/18	0.00	0.00	QC21			SRB 9-89

Part Op 110 - Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage one thread on three 5/16-18-015C Descriptions: bolts***

140 - Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041 Location :FG023

145 - Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box) as per PPP D350-615-041 CHG003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5/16-18-015C	SS Bolt 5/16-181.5"	75 Ea (3 ea)	90-Start up Operation	5078476
5/16WC	Washer	300 Ea (12 ea)	90-Start up Operation	5078477
7/16-14-050C	SS Bolt 7/16 5" Long GA156	25 pcs (1 ea)	90-Start up Operation	5078478
7/16WC	Washer, SS Flat 7/16 GA156	50 pcs (2 ea)	90-Start up Operation	5078479
D2282-041	T Assembly	25 Ea (1 ea)	90-Start up Operation	5098040
D2282-043	Saddle Assembly	25 Ea (1 ea)	90-Start up Operation	5098041
D3015-3	Locknut GA006	75 Ea (3 ea)	90-Start up Operation	5078341
D3015-5	SS Nylock Nut 7/16 GA006	25 Ea (1 ea)	90-Start up Operation	5078342

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	5/16-18-015C	75	200	0
	5/16WC	300	113	0
	7/16-14-050C	25	50	0
	7/16WC	50	35	0
	D2282-041	25	8	0
	D2282-043	25	5	0
	D3015-3	75	105	0
	D3015-5	25	60	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Part Specifications

Specifications could not be found.

Plex 6/1/18 12:51 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																									
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Description W Container No: S103088 Part: D350 - 615 - 041 Job No: 178533 Serial No/Batch: S103088 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Certificate of Conformity 06/15/18 Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																											
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verifcat ☐</td> <td style="width:35%;"></td> <td style="width:35%;"></td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td></td> <td></td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td></td> <td></td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td></td> <td></td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td></td> <td></td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>☐ Cuffs</td> <td>☐ Contamination</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>☐ Crushing</td> <td>☐ Countersink</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>☐ Heat Treat</td> <td>☐ Cut Too Short</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>☐ Wave/Twist in Tube</td> <td>☐ Instructions Incomplete/Unclear</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="2"></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td colspan="2">OTHER :</td> </tr> </table>								Root Cause				Environment ☐	No Re-verifcat ☐			Design ☐	Operator ☐			Doc/Data ☐	Offset/Setup ☐			Equip/Tooling ☐	Supplier ☐			Handling/Pre ☐	Training ☐			Material ☐	Use for Testing ☐	☐ Cuffs	☐ Contamination	Internal Transport ☐	Poor Information ☐	☐ Crushing	☐ Countersink	Tribal Knowledge ☐	Rushing ☐	☐ Heat Treat	☐ Cut Too Short	LOA ☐	Product Improvement ☐	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	Substation ☐	Process Improvement ☐	☐ Marks/Chatter	☐ Drill Holes	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐	OTHER :	
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